

Date: Tuesday, 13/01/2009 4:07:29 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM GUIDE
Job Number :	44733		
Estimate Number :	12657		
P.O. Number :		Part Number :	D35893
This Issue :	13/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3589 REV B PRELIM
First Issue :	/ /	Project Number :	N/A
Previous Run :	40368	Drawing Revision :	B PRELIM
Written By :	<u>mr 09-01-13</u>	Material :	
Checked & Approved By :		Due Date :	15/01/2009
Comment :	Est Rev:A 08-05-29 new issue DD verified by:EC		

Qty: 4 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



202.01.14 Per ECN #001502P

Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0260 0500	304 SS Roundbar .750
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Comment: Qty.: 0.0569 f(s)/Unit Total: 0.2276 f(s)

.500 3/4" 304 SS Roundbar

batch: M108415

09/01/15

(4 pcs)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA754 & DWG D3589

FOLIO REV: A

DWG REV: B PRELIM.

2-DEBURR AS REQUIRED

09/01/15

(4 pcs)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/01/15

(4 pcs)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ENGINEERING APPROVAL

09.01.15 4x

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/01/16

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/01/2009 4:07:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM GUIDE

Job Number: 44733

Part Number: D35893

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



mf 09-01-16

POSITIVE RECALL

EFFECTIVE 09-01-14 AUTH

RELEASED 1 DATE 09-02-17

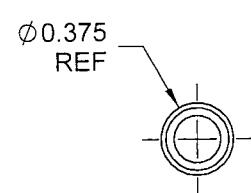
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

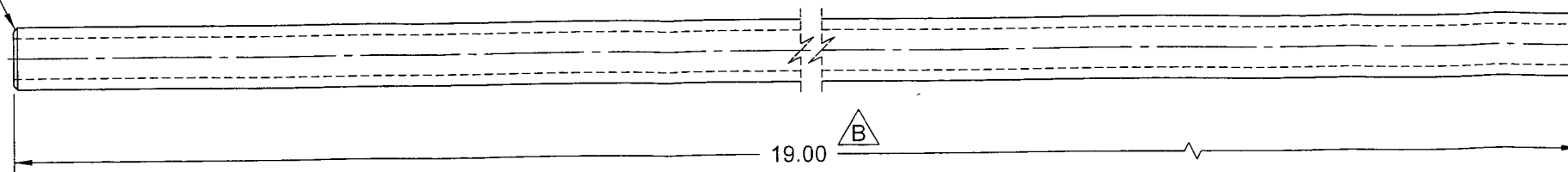
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

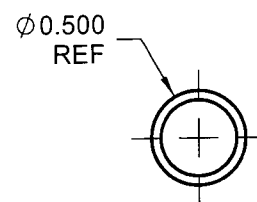


0.03 X 45°
CHAMFER
2 PL

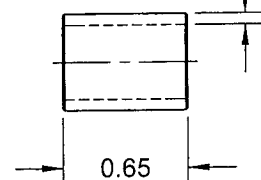


0.065
REF

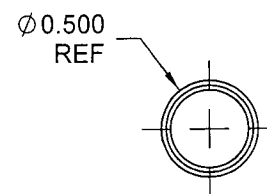
D3589-1 ARM



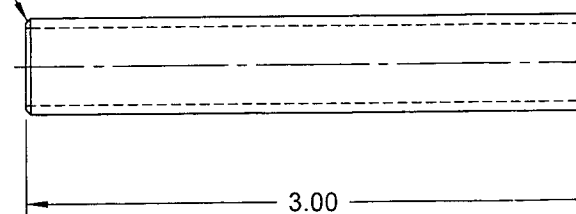
0.058
REF



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

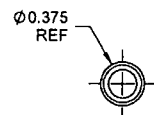
6) IDENTIFICATION: N/A

7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

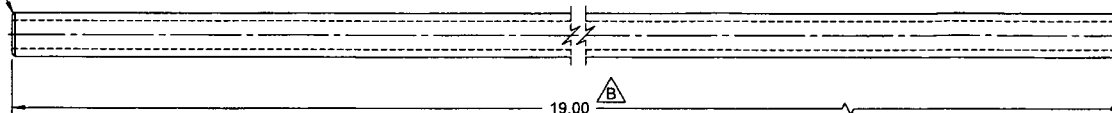
PRELIMINARY ISSUE

2009.01.14
REV DVC #01-302P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

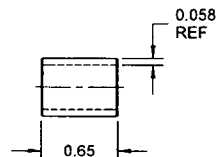
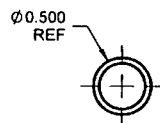


0.03 X 45°
CHAMFER
2 PL

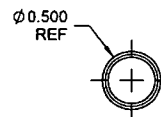


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REF

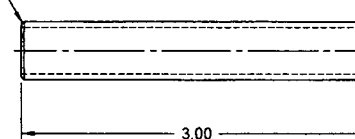
D3589-1 ARM



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

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D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

44433

RELEASED
09/02/05

DESIGN	<i>HA</i>	DART AEROSPACE LTD	
DRAWN	<i>HA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>HA</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>HA</i>	D3589	SHEET 4 OF 8
APPROVED	<i>HA</i>	TITLE	SCALE
DE APPR.	<i>HA</i>	LATCH ASSEMBLY	NTS
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